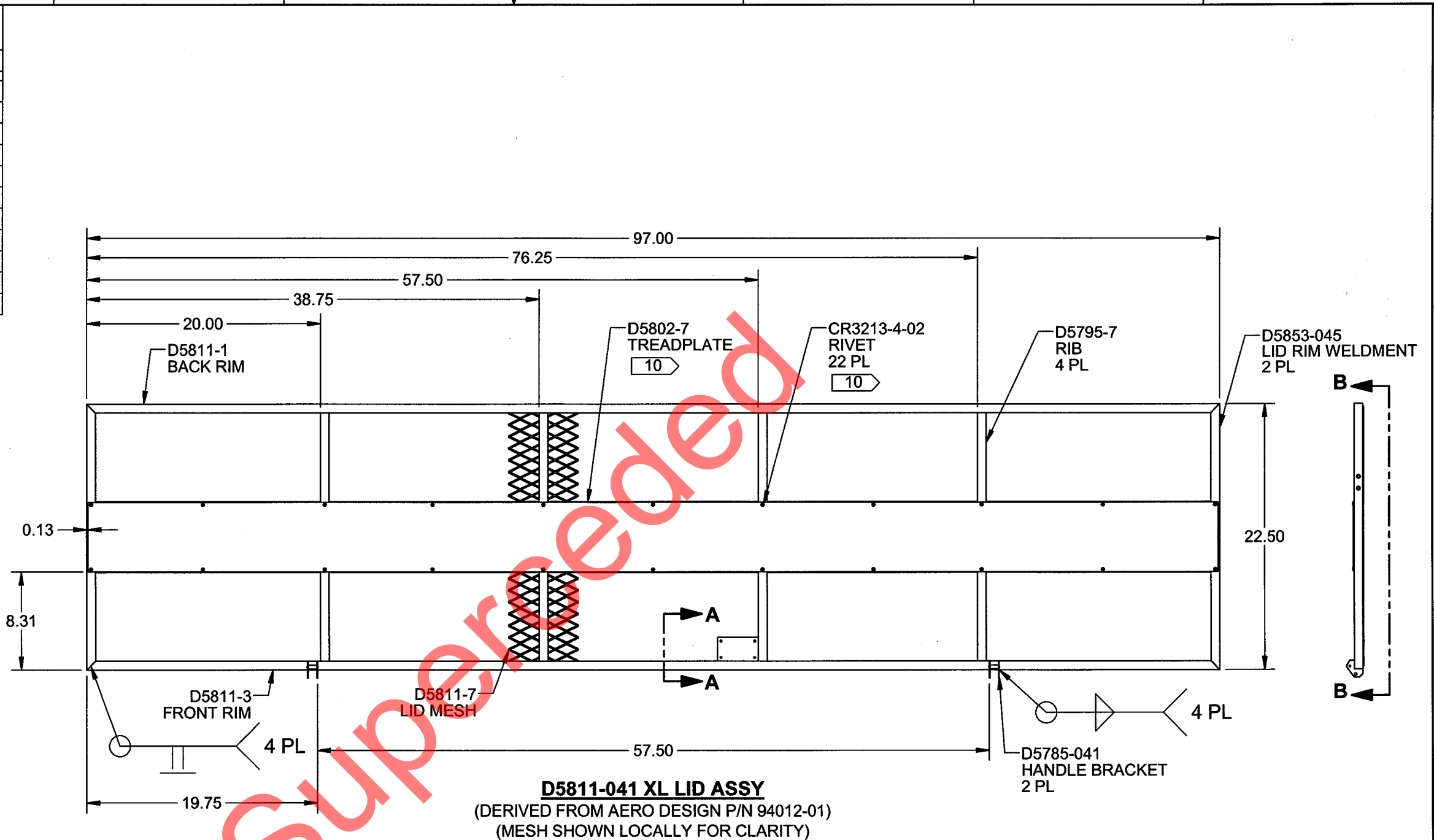


QTY -041	P/N	DESCRIPTION
X	D5811-041	XL LID ASSY
2	D5785-041	HANDLE BRACKET
4	D5795-7	RIB
6	D5795-11	STRINGER
1	D5795-15	PLACARD BRACKET
1	D5802-7	TREADPLATE
1	D5811-1	BACK RIM
1	D5811-3	FRONT RIM
4	D5811-5	STRINGER
1	D5811-7	LID MESH
2	D5853-045	LID RIM WELDMENT
22	CR3213-4-02	RIVET

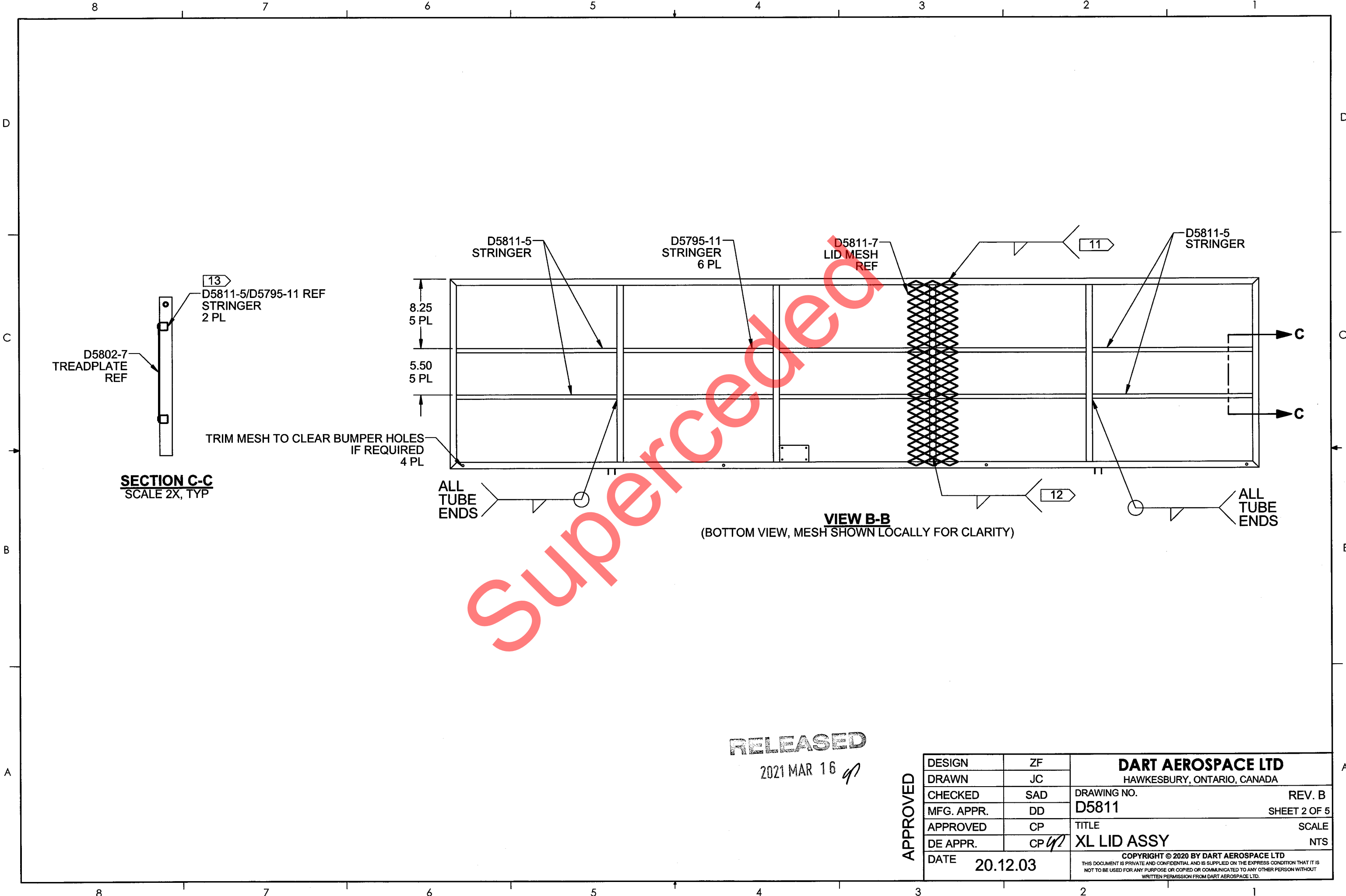


- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3.
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 23.44 lbs
 - 8) WELD PER DART QSI 004. IT IS PERMISSIBLE TO GRIND OR BUFF TO CLEAN UP WELDS
 - 9) DRILL #30 (Ø0.129) VENT HOLES AS REQUIRED. FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD PRIOR TO FINISH.
 - 10) INSTALL TREADPLATE AFTER FINISH. TRANSFER MARK AND DRILL HOLES Ø0.129 +0.003/-0.000 FROM TREADPLATE TO LID. FAY SEAL SURFACES BETWEEN LID AND TREADPLATE WITH RTV SILICONE. SECURE TREADPLATE WITH RIVETS.
 - 11) WELD EVERY MESH INTERSECTION ALONG RIM.
 - 12) FOR EACH RIB, WELD FIRST 5 MESH INTERSECTIONS DOWN EACH END THEN EVERY 2ND MESH INTERSECTION MINIMUM.
 - 13) ALIGN STRINGERS TO TOP OF LID.
 - 14) LOCATE D5795-15 PLACARD BRACKET FLUSH WITH BOTTOM OF LID. TRIM MESH TO CLEAR BRACKET LEAVING 0.25 OVERLAP. WELD MESH TO BRACKET.

RELEASED
 2021 MAR 16
 HB ECR 21-132

APPROVED

B	SHT 1: REMOVED NOTE 13. SHT 2 ZNC3: REMOVED WELD SYMBOL FOR MESH TO STRINGER. SHT 3&4: UPDATED NOTE 1. SHT 5: ADDED NOTE 8	JC	20.12.03
A	NEW ISSUE	ZF	20.01.21
REV.	DESCRIPTION	BY	DATE
DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. D5811 REV. B	
MFG. APPR.	DD	SHEET 1 OF 5	
APPROVED	CP	TITLE XL LID ASSY SCALE NTS	
DE APPR.	CP		
DATE	20.12.03	COPYRIGHT © 2020 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



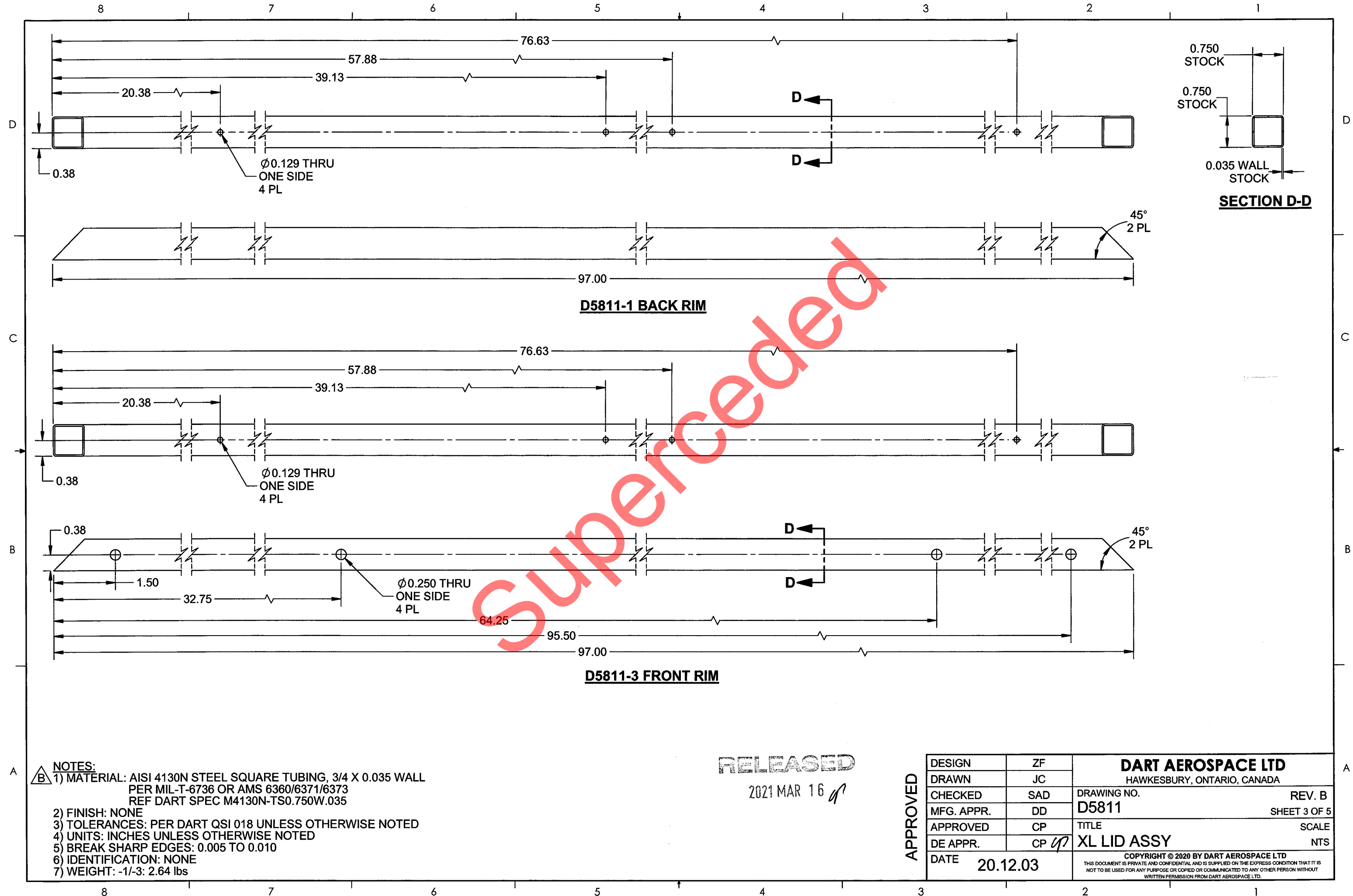
SECTION C-C
SCALE 2X, TYP

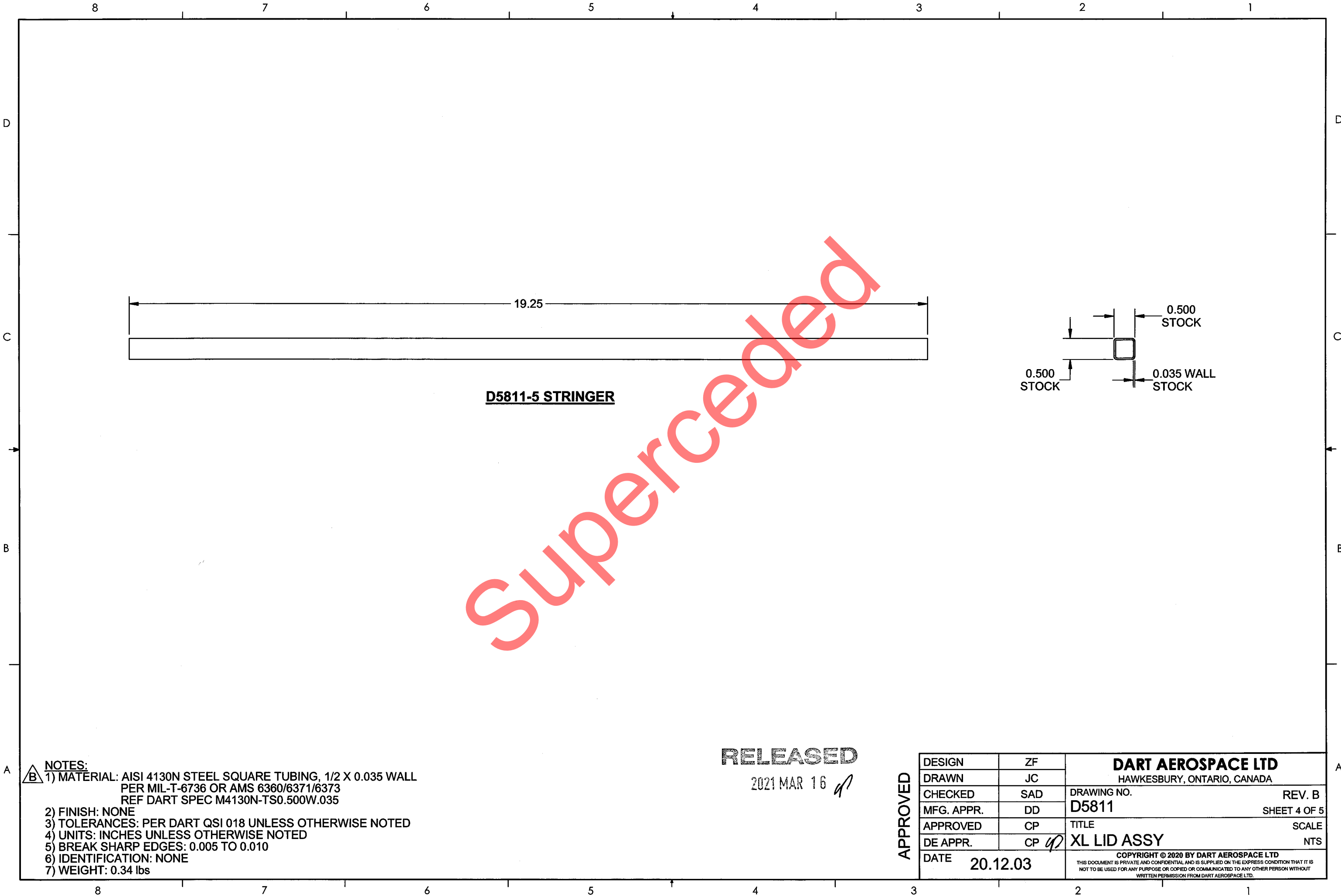
VIEW B-B
(BOTTOM VIEW, MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2021 MAR 16 *q1*

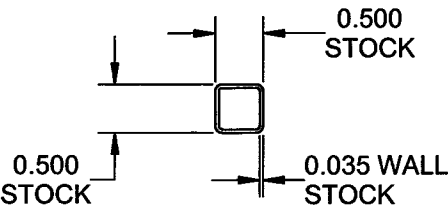
APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO.	REV. B
MFG. APPR.	DD	D5811	SHEET 2 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP <i>q1</i>	XL LID ASSY	NTS
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D5811-5 STRINGER



Superceded

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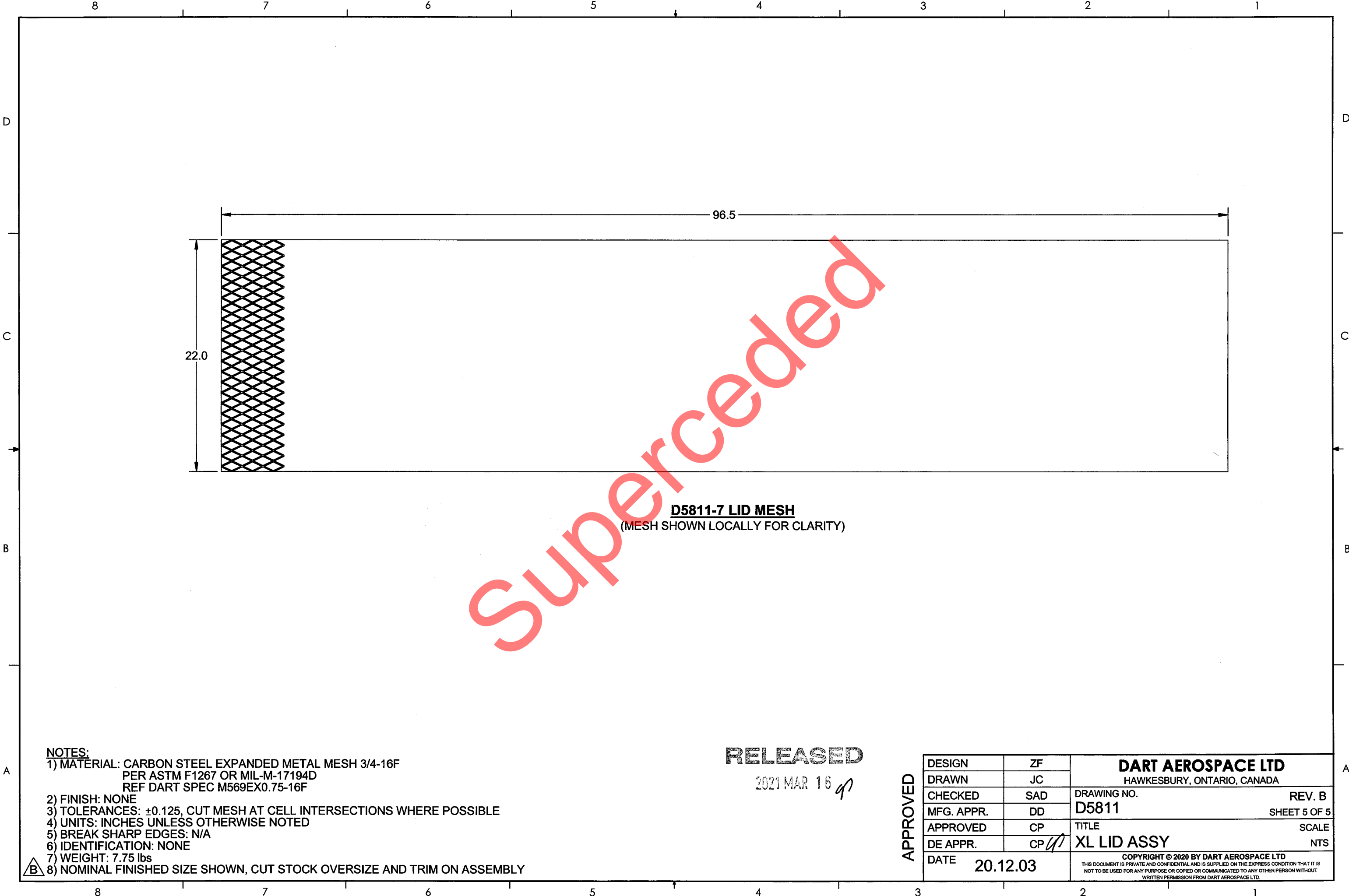
2021 MAR 16

[Signature]

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO. D5811	REV. B
MFG. APPR.	DD		SHEET 4 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP <i>qd</i>	XL LID ASSY	NTS
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- NOTES:**
- 1) MATERIAL: AISI 4130N STEEL SQUARE TUBING, 1/2 X 0.035 WALL
PER MIL-T-6736 OR AMS 6360/6371/6373
REF DART SPEC M4130N-TS0.500W.035
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.34 lbs



D5811-7 LID MESH
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:
- 1) MATERIAL: CARBON STEEL EXPANDED METAL MESH 3/4-16F
PER ASTM F1267 OR MIL-M-17194D
REF DART SPEC M569EX0.75-16F
 - 2) FINISH: NONE
 - 3) TOLERANCES: ± 0.125 , CUT MESH AT CELL INTERSECTIONS WHERE POSSIBLE
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.75 lbs
 - 8) NOMINAL FINISHED SIZE SHOWN, CUT STOCK OVERSIZE AND TRIM ON ASSEMBLY

RELEASED
2021 MAR 16 *qp*

APPROVED

DESIGN	ZF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC		
CHECKED	SAD	DRAWING NO.	REV. B
MFG. APPR.	DD	D5811	SHEET 5 OF 5
APPROVED	CP	TITLE	SCALE
DE APPR.	CP <i>qp</i>	XL LID ASSY	NTS
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